

October 6, 2011 9:16:51 AM

74766

U/R

Page 1

Item ID: D2940-1

Revision ID: U/R

Item Name: Support

Start Date: 10/06/11

Start Qty: 20.00

20

Required Date: 11/15/11

Req'd Qty: 20.00

20

Reference:

Cust Item ID:

Customer:

Approvals:

Process Plan: *ALU*

Date: 11 / 10 / 20 Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

NR1

NR2

[illegible]

Work Order ID 74766

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Page 2

Item ID: D2940-1

Accept

N900040100

Setup Start ***NS1***

Revision ID: U/R

Item Name: Support

Stop ***NS2***

Start Date: 10/06/11 Start Qty: 20.00

20

Cust Item ID:

Required Date: 11/15/11 Req'd Qty: 20.00

20

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

130

130

HandFXtube

Hand Finishing Crosstubes

Memo

Per note 8 on page 1 of dwg D2940, Prep inner concave surface of support and apply 3M Scotch-Weld as per dwg. 24h of cure time.

0.00

0.00

140

140

QC

Quality Control

QC3- Inspect Part Finish

Memo

0.00

0.00

8 u/a/13

170

170

Packaging

Packaging

Identify as per dwg & Stock Location: *X file*

Memo

0.00

0.00

assy

AS 11 - 11 - 11 **(Pto)**

44 ~~11-11-12~~ **(4)**

45 11 - 11 - 13 **(4)**

W/O: 74766-3		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D29407 PAR #: _____ Fault Category: Finish NCR: Yes No DQA: u Date: 11/11/15
 Resolution: Re work Disposition: Re work QA: N/C Closed: ck Date: 11/11/16

NCR: 11-9583		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
11-11-12	130	Scott's Weld Adhesive 2216 B/A Gray ratio was mixed backwards after 24 hours not cured too soft too sand R.C. 600.	S ulul13 251012	Remove uncured epoxy prep surface as per Dwg re-apply Scott's Weld Adhesive allow to cure 24hrs	RT 11-11-12	S ulul13 7:00AM	S ulul13	S ulul13
			↓	Retrain employees to correctly mix as per instructions			AS2047 ↓	S ulul13

NOTE: Date & initial all entries

74766

Page 3

Accept

N900040100

Setup Start *NS1*

Stop *NS2*

Start Date: 10/06/11 **Start Qty:** 20.00

20

Cust Item ID:

Required Date: 11/15/11 **Req'd Qty:** 20.00

20

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Operation	Description
1	Start
2	Read input
3	Process input
4	Output result
5	End

Set Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

180

QC21- Final Inspection - Work Order Release

0.00

180

QC

Memo

0.00

Quality Control

Number Stamp
11/11/14

11-11-14

Picklist Print

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Page 1

Work Order ID: 74766

74766

Parent Item: D2940-1

D2940-1

Parent Item Name: Support

Start Date: 10/06/11

Required Date: 11/15/11

Start Qty: 20.00

Required Qty: 20.00

Comments:

IPP C 02.11.26 Reformat; Added P/OKJ

IPP Rev:D Added priming as per Rev B 07-04-30 JLM

IPP E 08.03.19 Re-format Ec verified by DD

IPP Rev:F 08-10-22 add qc14 DD verified by:EC

IPP Rev:G

11.08.04 as per dwg rev.C DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
DSK081		Manufactured	No			110	Each	14.0000	0.5	10.52632			

DSK081

D2940-1 TURNING DETAIL

**

Location

Loc Qty

Loc Code

MAT

4

69717

4

MAT050

10

72867

10

1/2 Ins/H 11-08

DART AEROSPACE LTD		Work Order: 74766
Description: Ø3.250 Support		Part Number: D2940-1
Inspection Dwg: D2940	Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION DIMENSION SHEET

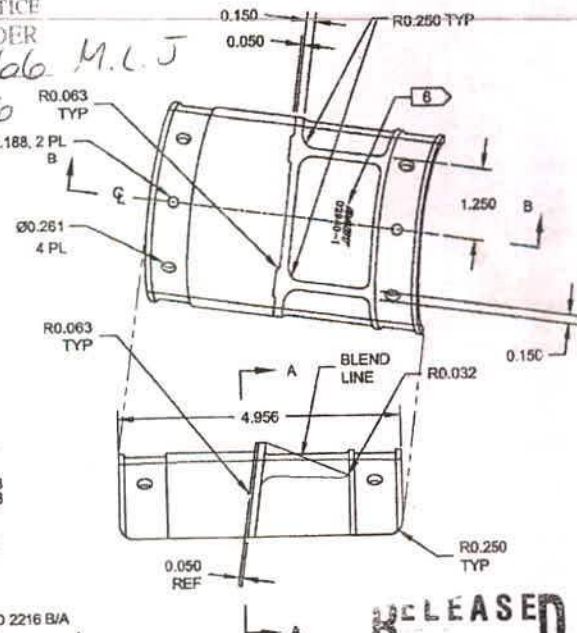
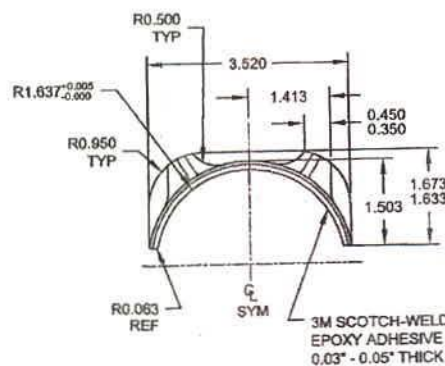
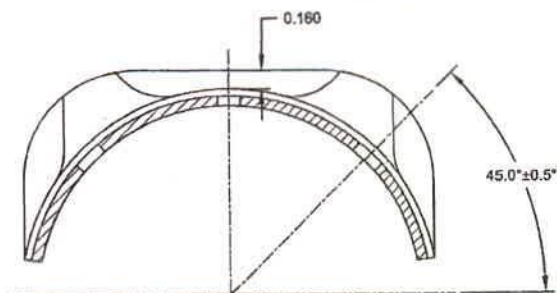
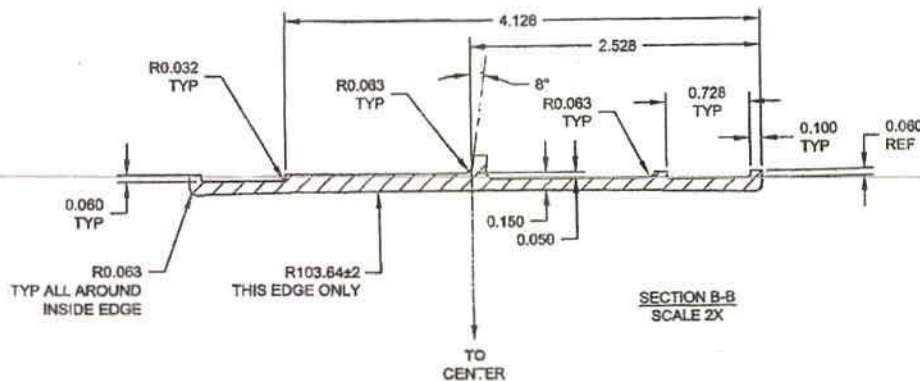
☒ First Article ☐ Prototype

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	5
HAAS Section								
AA	0.240	0.260		.250	.250	.250	.250	.250
AB	0.490	0.510		.500	.500	.500	.500	.500
AC	0.140	0.160		.155	.155	.155	.155	.155
AD	3.510	3.530		3.522	3.522	3.524	3.524	3.524
AE	1.633	1.673		1.660	1.663	1.664	1.664	1.664
AF	1.493	1.513		1.503	1.503	1.503	1.503	1.503
AG	0.040	0.060		.050	.05	.05	.05	.05
AH	0.188	0.193		.189	.189	.189	.189	.189
AI	0.140	0.160		.150	.150	.150	.150	.150
AJ	2.518	2.538		2.528	2.528	2.528	2.528	2.528
AK	0.040	0.060		.050	.050	.050	.050	.050
AL	0.010	0.020		.010	.010	.010	.010	.010
AM	0.140	0.160		.153	.153	.153	.153	.153
AN	0.350	0.450		.400	.400	.400	.400	.400
AO	0.240	0.260		.250	.250	.250	.250	.250
AP	0.150	0.170		.160	.160	.160	.160	.160
AQ	0.053	0.073		.06	.06	.06	.06	.06
AR	101.64	105.64		✓	✓	✓	✓	✓
AS	0.260	0.267		.260	.260	.260	.260	.260
AT	0.053	0.073		.063	.063	.063	.063	.063
AU	4.118	4.138		4.130	4.130	4.130	4.130	4.130
AV								
AW								
Accept/Reject								

Measured by: [Signature]	Date: 11/11/11
Audited by: [Signature]	Date: 11/11/11
Prototype Approval:	Date:

Rev	Date	Change	Revised by	Approved
A	02.12.12	New Issue	KJ/RF	
B	07.05.08	Dwg Rev. updated	KJ/JLM	
C	07.07.18	Dimension AS revised	KJ/JLM	
D	08.04.22	Reformat	KJ/JLM	[Signature]

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 74766 M.L.J
11/10/06



RELEASED
2011-07-28

NOTES:

- 1) MATERIAL: 17-4 PH STAINLESS STEEL, H900 OR H925 CONDITION
MIN UTS = 170 KSI (38 HRc)
(REF DART SPEC. D6104)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 (REF X.XXX = ±0.010) UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: DART LOGO (PER DART SUPPLIED GRAPHIC) AND PART NUMBER IN THIS AREA WITH 0.125 HIGH LETTERING
0.010-0.020 DEEP, PER DART QSI 044 6.3.
- 7) WEIGHT: 0.92 lb
- 8) FOR THE ENTIRE INNER CONCAVE SURFACE:
ABRADE SURFACE WITH 400-GRIT SANDPAPER. REMOVE RESIDUE WITH MEK (OR EQUIVALENT). APPLY 0.03\"/>

D2940-1 SUPPORT

C	RMV FINISH, ADD 3M 2216, ADD H925 MAT'L OPTION	CP	11.07.15
B	UPDATE PER NCR 642, PRIME INSIDE	PH	07.03.13
A	NEW ISSUE	CP	01.01.10
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	11.07.15		

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. D2940	REV. C SHEET 1 OF 1
TITLE Ø3.250 SUPPORT	SCALE NTS
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